



## PATENT ABSTRACTS OF JAPAN

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**B21B 1/00****B21B 1/46****B22D 11/12**(21) Application number: **56032772**(22) Date of filing: **07.03.81**(71) Applicant: **KAWASAKI STEEL CORP**(72) Inventor: **TAGI TOSHIO  
NITO TAKASHI****(54) HOT ROLLING LINE FOR SLAB BY PLURAL  
CONTINUOUS CASTING INSTALLATIONS OF  
DIFFERENT KINDS**

(57) Abstract:

PURPOSE: To provide a titled line which permits selective hot rolling of the respective slabs from plural continuous casting installations of different kinds by combining an existing roller guide type continuous casting installation permitting production of the slabs of many kinds of steels a rotary belt type continuous casting installation of a high casting speed permitting production of the thin-walled slabs a hot rolling line.

CONSTITUTION: After the slab cast with an existing roller guide type continuous casting installation 11 is cut 12 to each prescribed length, the cut slabs are conveyed to a heating furnace inlet side table 14, by which they are charged into a heating furnace 15. The slabs heated to about 1,200°C in the furnace 15 are charged via a furnace outlet side table 16 to a roughing mill group 17, by which they are molded to the sheet bars. Thereafter, the sheet bars are cut 18 of the leading and trailing ends, and are charged 19 into finishing mills 20. The finish rolled hot strips are coiled with a coiler 22. On the other hand, the thin-walled slab cast with a rotary belt type continuous casting installation 31 disposed in parallel with the installation 11 is cut 32 to sheet bars of

every prescribed length, after which the sheet bars are passed through a heat retaining furnace 33 and are coiled with an un-coiler carriage 34. Next, the sheet bars are un-coiled from the carriage 34 and are charged into the mills 20, by which they are rolled to hot strips which are coiled with the coiler 22.

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